

Work Order ID 138275

Tuesday, October 27, 2015 11:06:53 AM

138275

Page 1

Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out

Start Date: 10/14/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: OCT 28 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9590

F

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-567-141 CHG004

ML5 15-11-25
(2)

DAS
28
9-09

NOV 26 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

NOV 25 2015

DAS
27
9-09

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-09

NOV 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Picklist Print

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Work Order ID: 138275

138275

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 10/14/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER
DSI9590 REV.E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM
VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-047		Manufactured	No				Each	1.0000	1	2			
2 *D4434-047*									**				
Cover Assembly													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST619				1					
				130226				1					
D3802-1		Manufactured	No			110	f	90.7500	2	4			
2 *D3802-1*									**				
Windows Seal (\$ Per Foot)													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST421				90.75					
				134091				90.75					
D4434-041		Manufactured	No			110	Each	7.0000	1	2			
2 *D4434-041*									**				
Fwd Bracket Assembly													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST623				7					
				135963				7					
D4435-045		Manufactured	No			110	Each	7.0000	1	2			
2 *D4435-045*									**				
T/R Bellcrank Cover Assembly													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST620				7					
				127215				7					

DAS
28
9-89
NOV 25 2015
BAS
27
9-89

DAS
28
9-89
NOV 25 2015
BAS
27
9-89

DAS
28
9-89
NOV 25 2015
BAS
27
9-89

DAS
28
9-89
NOV 25 2015
BAS
27
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Page 2

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Work Order ID: 138275

138275

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 10/14/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

D4435-9 Manufactured No

110 Each 4.0000 2 4

**

139316 *SL* *BAS*
27
9-89

2 ***D4435-9***
Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST098

4

135541

4

D4436-041 Manufactured No

110 Each 4.0000 1 2

**

139356X1 *BAS*
27
9-89

2 ***D4436-041***
Aft Bracket Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST613

4

136525

4

D4441-1 Manufactured No

110 f 502.1190 2 4

**

DAS
6
9-89

2 ***D4441-1***
Rubber Seal

DAS
28
9-89

Location

Loc Qty

Loc Code

ST407

355.875

120932

355.875

ST422

146.244

120932

146.244

AN3-3A Purchased No

110 Each 200.0000 7 14

**

DAS
6
9-89

2 ***AN3-3A***
Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST338a

200

m131624

200

DAS
6
9-89

BAS
27
9-89
NOV 25 2015

Tuesday, October 27, 2015 11:06:53 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 10/14/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

AN525-10R6

Purchased

No

110

Each

36.0000

2

4

DAS
6
9-89

DAS
27
9-89

2 ***AN525-10R6***

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST329

36

M131420

36

AN525-832R7

Purchased

No

110

Each

52.0000

2

4

DAS
6
9-89

DAS
27
9-89

2 ***AN525-832R7***

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST328

52

m131957

52

MS21042L06

Purchased

No

110

Each

215.0000

7

14

DAS
6
9-89

DAS
27
9-89

2 ***MS21042L06***

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST304

212

m132803

64

m133316

48

m133363

100

ST305

3

m131317

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 10/14/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

110

Each

454.0000

2

4

133483

DAS
27
1-619

MS21042L08

Nut

Location

Loc Qty

Loc Code

CA 101

m129682 101

GA 204

m133134 204

ST304 149

m128401 102

m128429 3

m131317 26

m132930 18

DAS
28
9-89

MS21042L3

Purchased

No

110

Each

564.0000

5

10

133498

DAS
27
1-619

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001 334

M130922 334

GA 136

M131317 136

ST305 94

116549 12

126333 49

M128754 2

M132123 17

M132382 2

M132883 8

M133134 4

DAS
28
9-89

NOV 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																					
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																					
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																					
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																					
OTHER : ☐																																																																								

Picklist Print

Tuesday, October 27, 2015 11:06:53 AM

Work Order ID: 138275

138275

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 10/14/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS21059L3

Purchased

No

110

Each

217.0000

2

4

DAS
6
9-89

BAS
27
9-89

**

MS21059L3

Nut Plate

Location

Loc Qty

Loc Code

CA	16	
M129682	16	
cck007a	100	
M133363	100	
GA	3	
113749	1	
M132677	2	
ST303	98	
M131616	18	
M133016	30	
M133031	50	

DAS
28
9-89

MS35206-229

Purchased

No

110

Each

78.0000

7

14

DAS
6
9-89

BAS
27
9-89

**

MS35206-229

Screw

Location

Loc Qty

Loc Code

ST277	78	
M132763	78	

DAS
28
9-89

NOV 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, October 27, 2015 11:06:53 AM

Work Order ID: 138275

138275

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 10/14/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0332P

Purchased

No

110

Each

1,515.000

12

24

M123185

DAS
27
9-89

NAS1149F0332P

Washer

601.1607 CL

NOV 26 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

162

122063

162

ST260a

636

m128401

6

m131026

80

m131697

50

m133284

500

st268

117

123900

7

m130388

86

m133077

24

ST288

600

m133134

600

NAS1149FN616P

Purchased

No

110

Each

148.0000

14

28

DAS
27
9-89

NAS1149FN616P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST267

148

M132763

148

NAS1149FN816P

Purchased

No

110

Each

788.0000

2

4

DAS
27
9-89

NOV 25 2015

NAS1149FN816P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

st268

788

117316

788

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

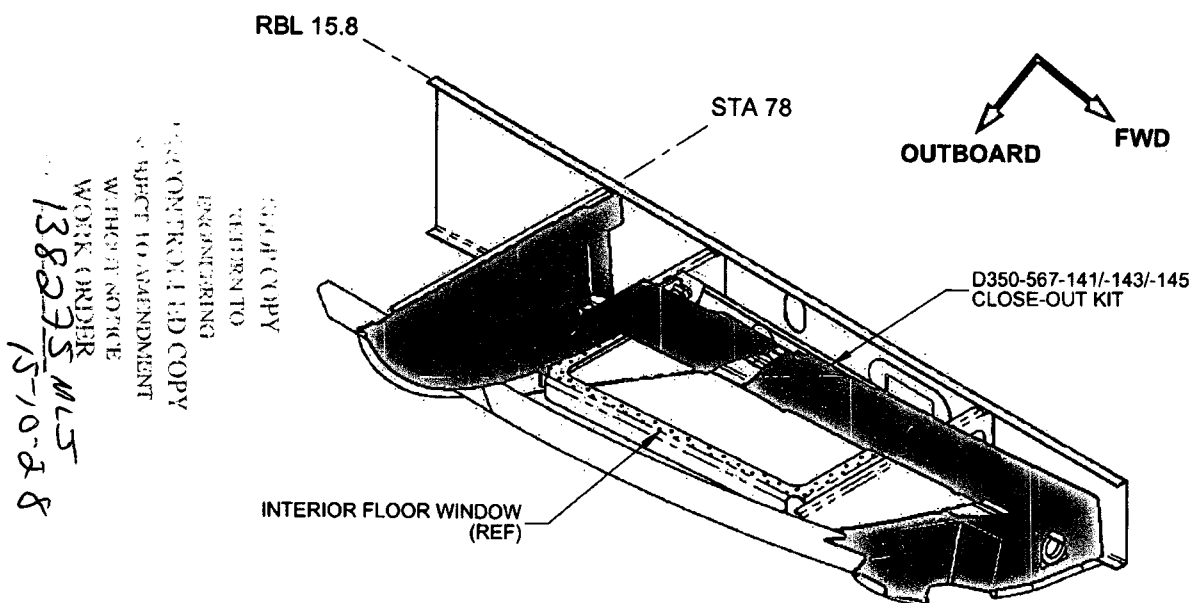


Figure 1. Floor Window Close-out Kit Installation

F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
E	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-832R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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BRANCH
DAO # 01-O-01

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2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-k	1.66 m	2.94 m-k

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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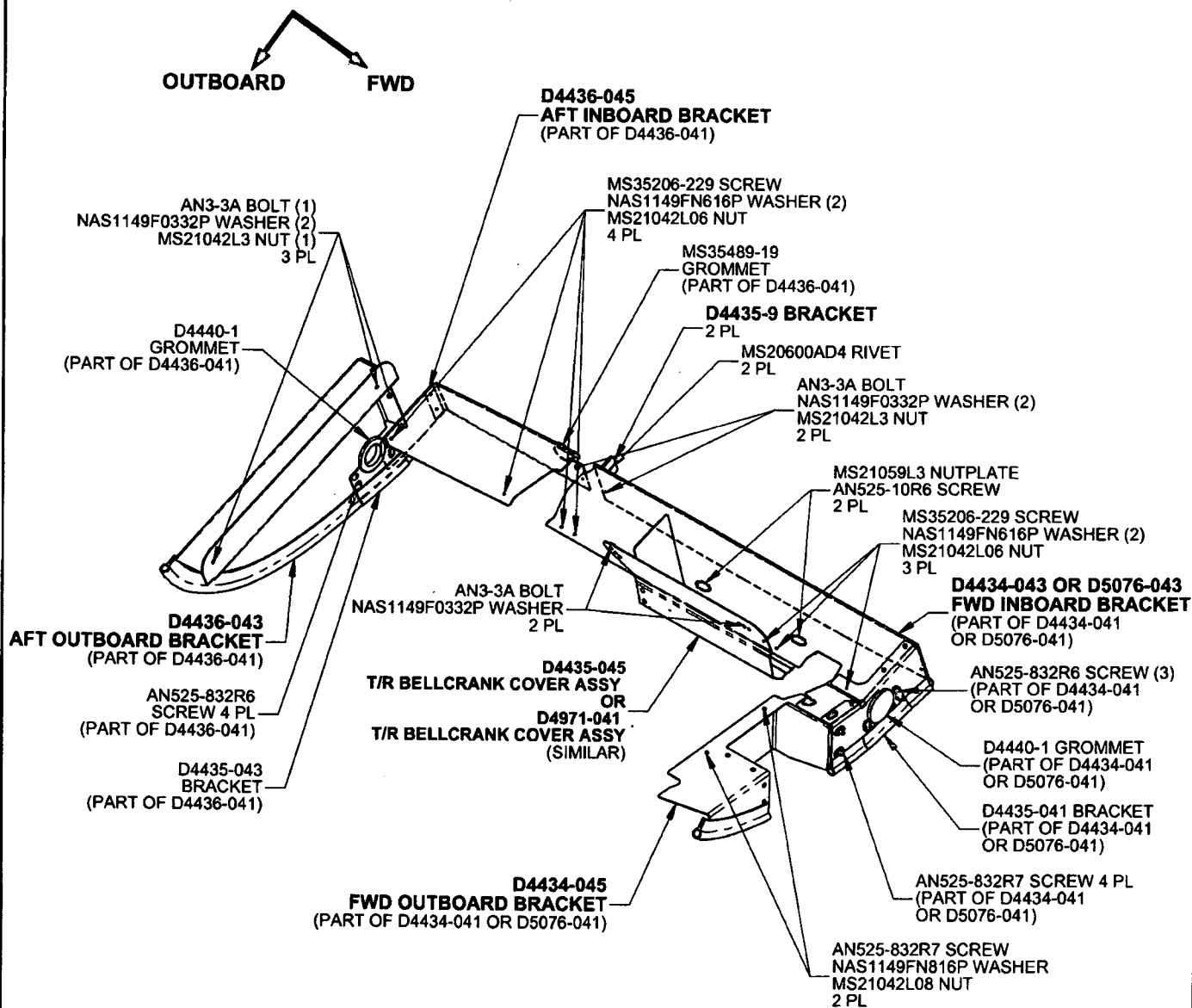


Figure 2. Floor Window Close-out Kit Installation

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D. SHEPHERD (DE # 02)

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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 /D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

F 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.10 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

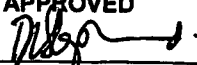
4.11 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.
 - d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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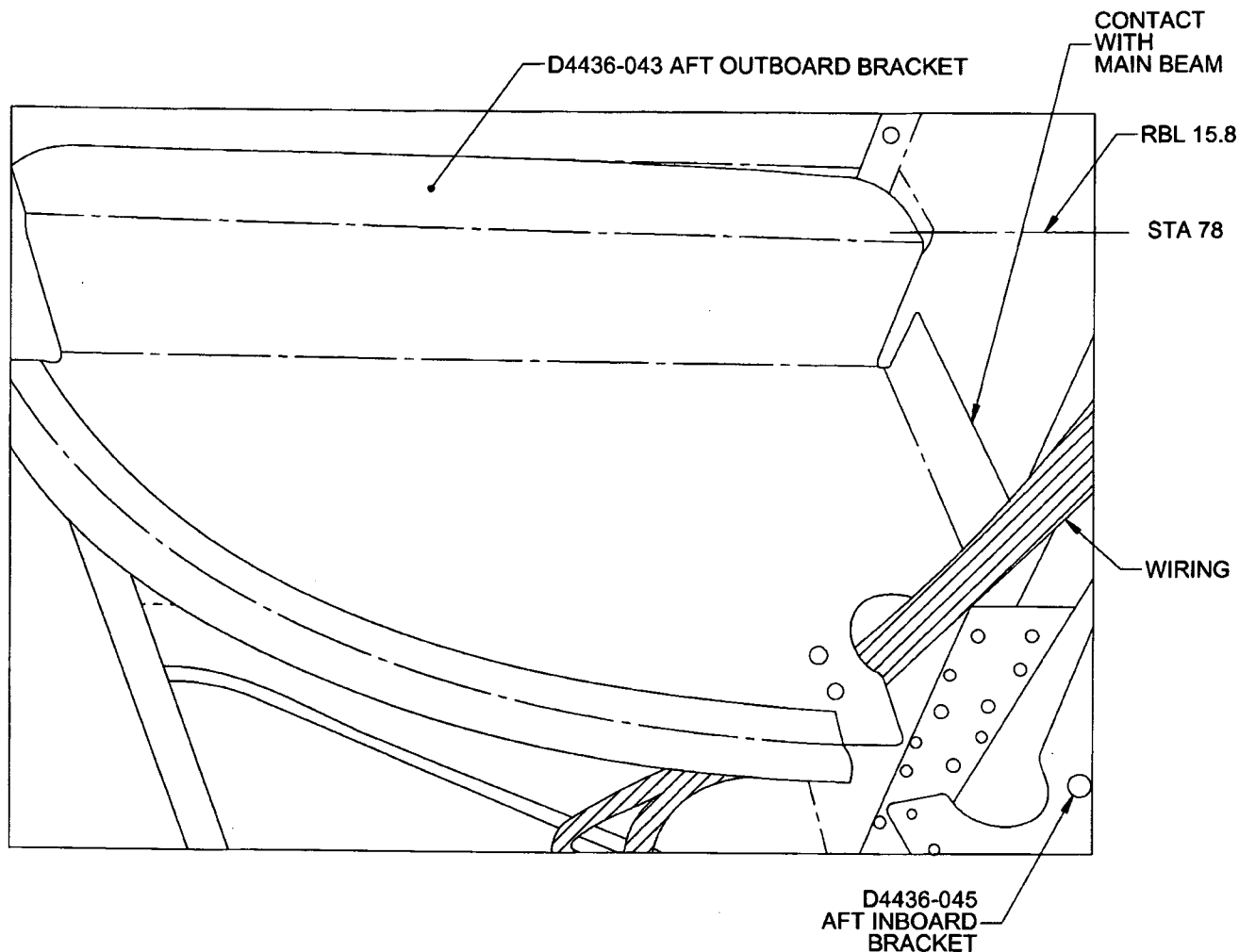


Figure 3. D4436-043 Aft Outboard Bracket Installation

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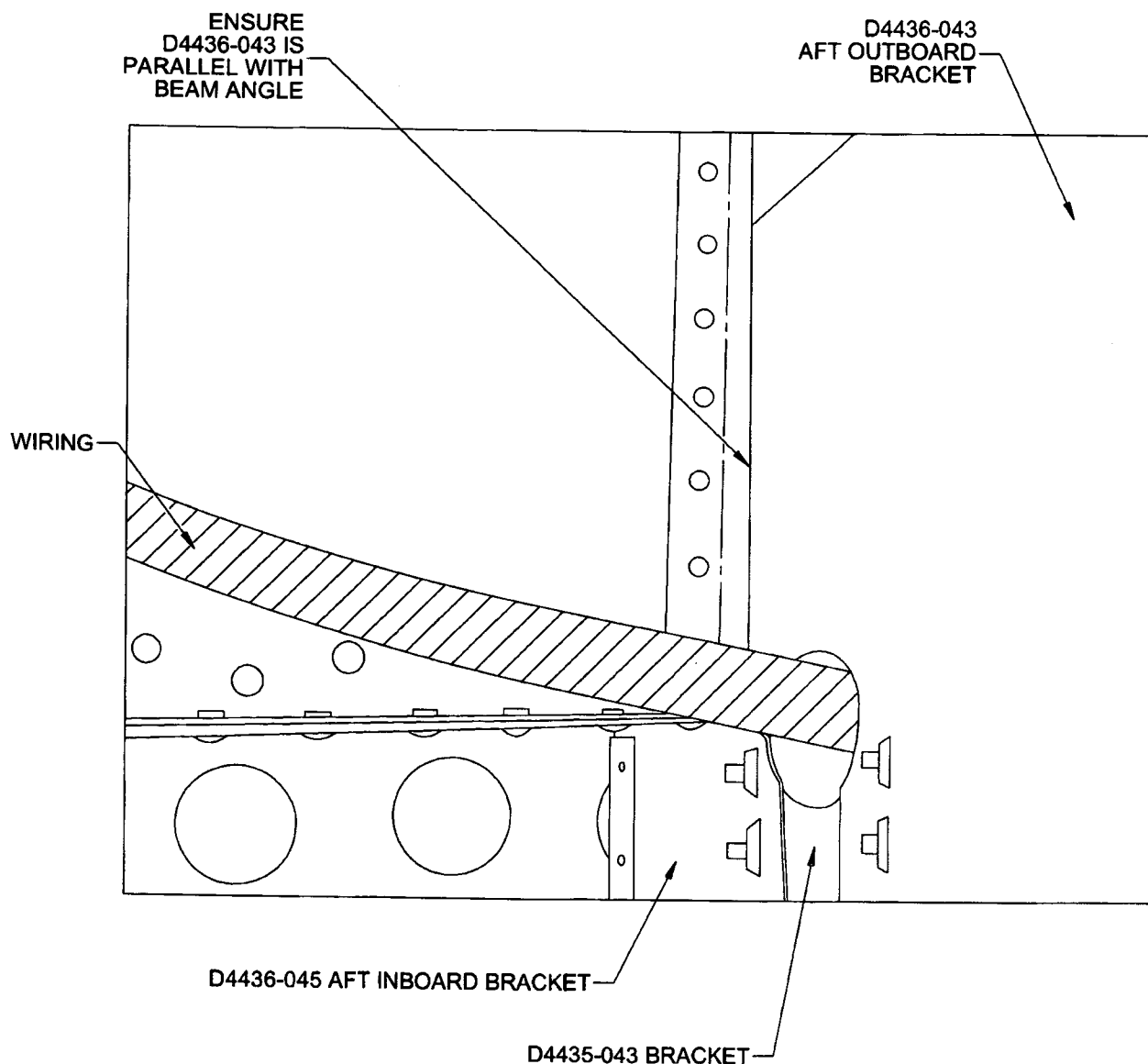


Figure 4. D4436-043 & D4435-043 Brackets Installation

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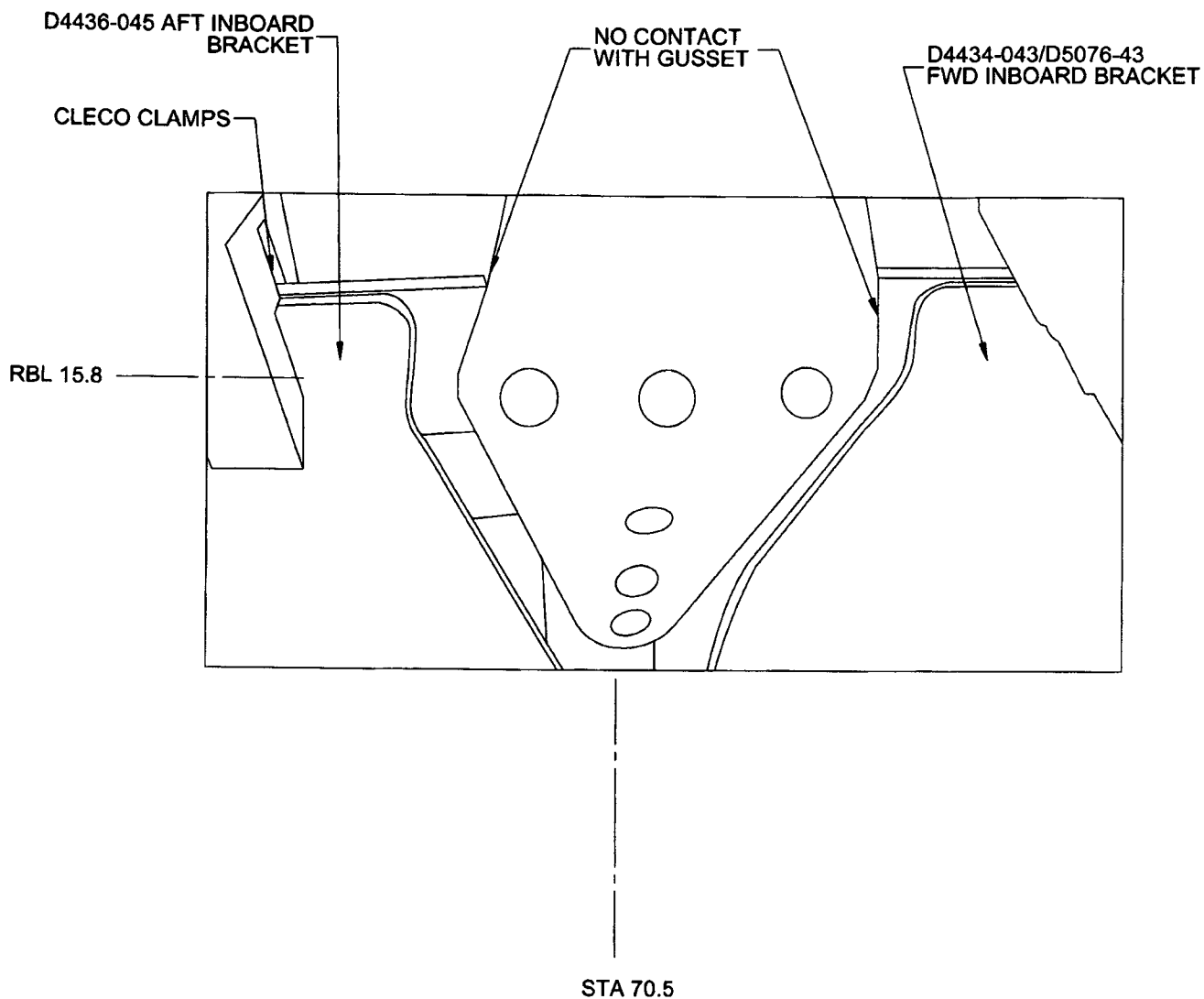


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 8 OF 19
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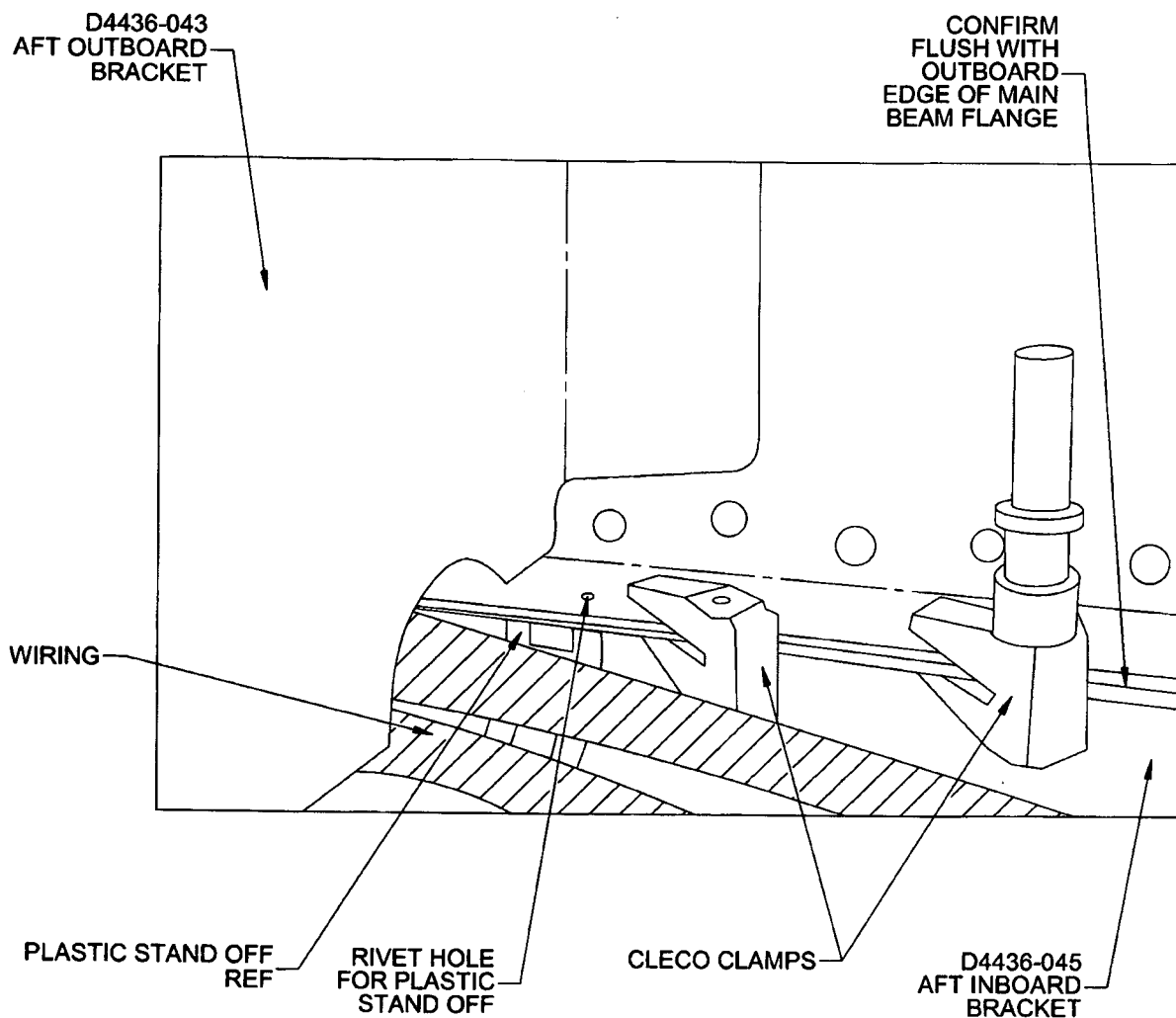


Figure 6. D4436-043 & D4436-045 Brackets Installation

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BRANCH
DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9590	SHEET 9 OF 19
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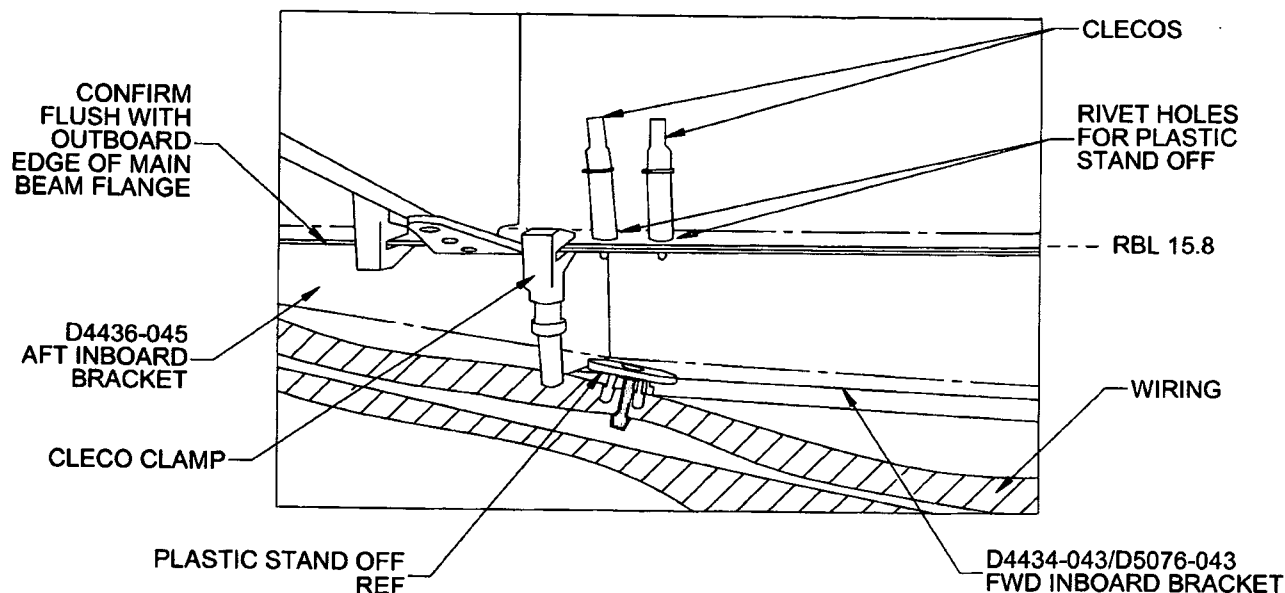


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

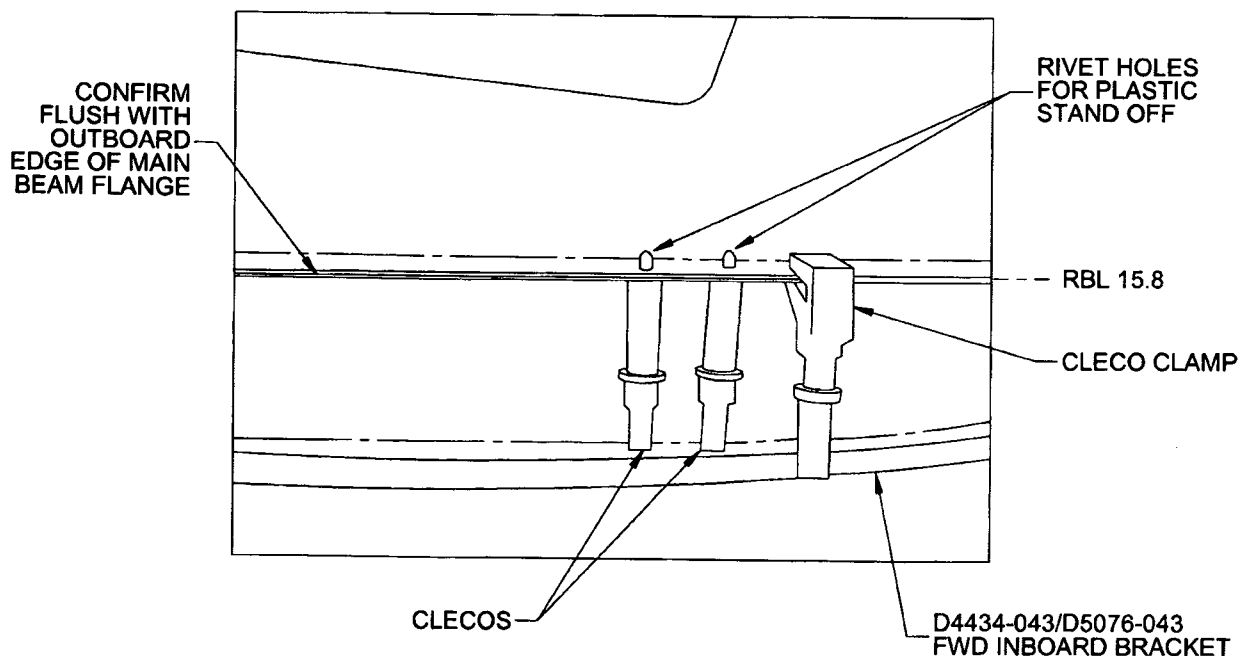


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

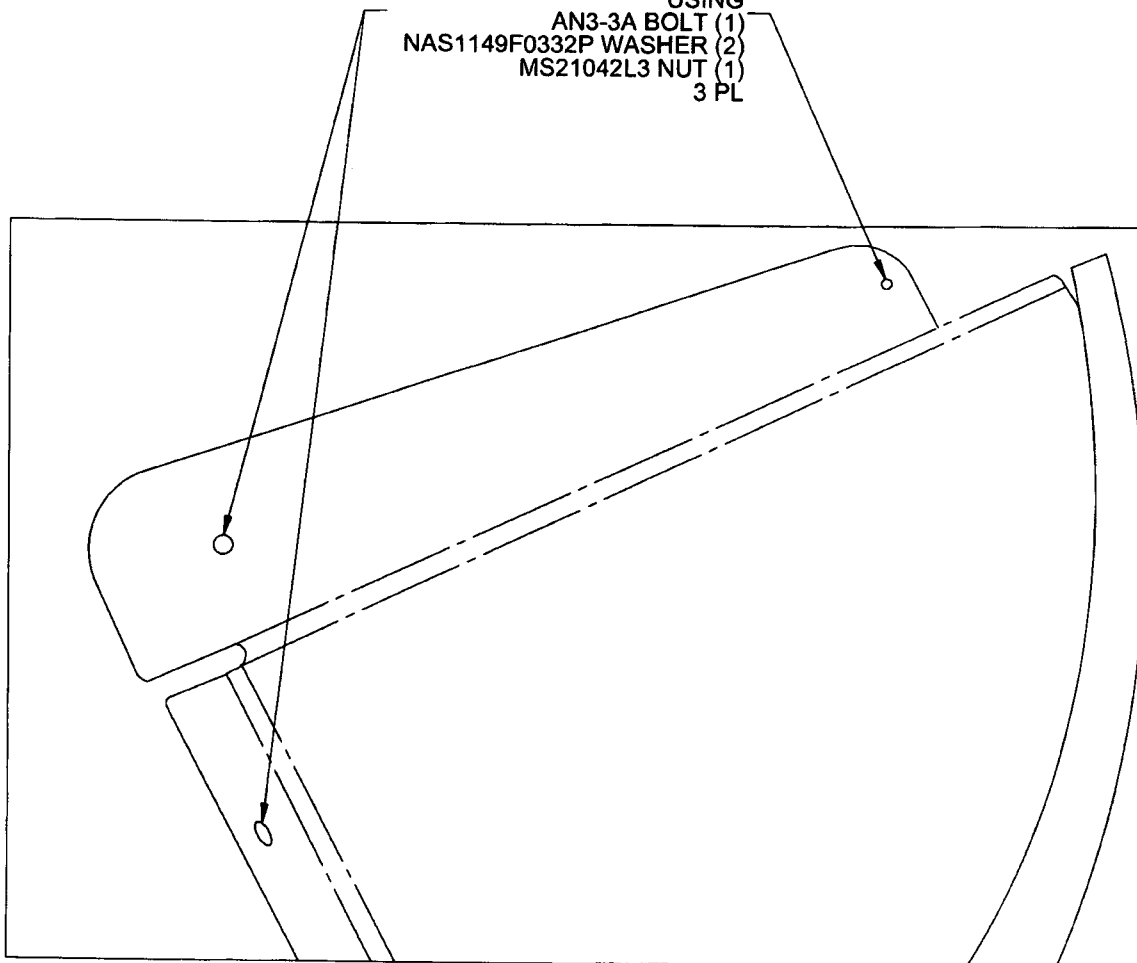


Figure 9. D4436-043 Aft Outboard Bracket Installation

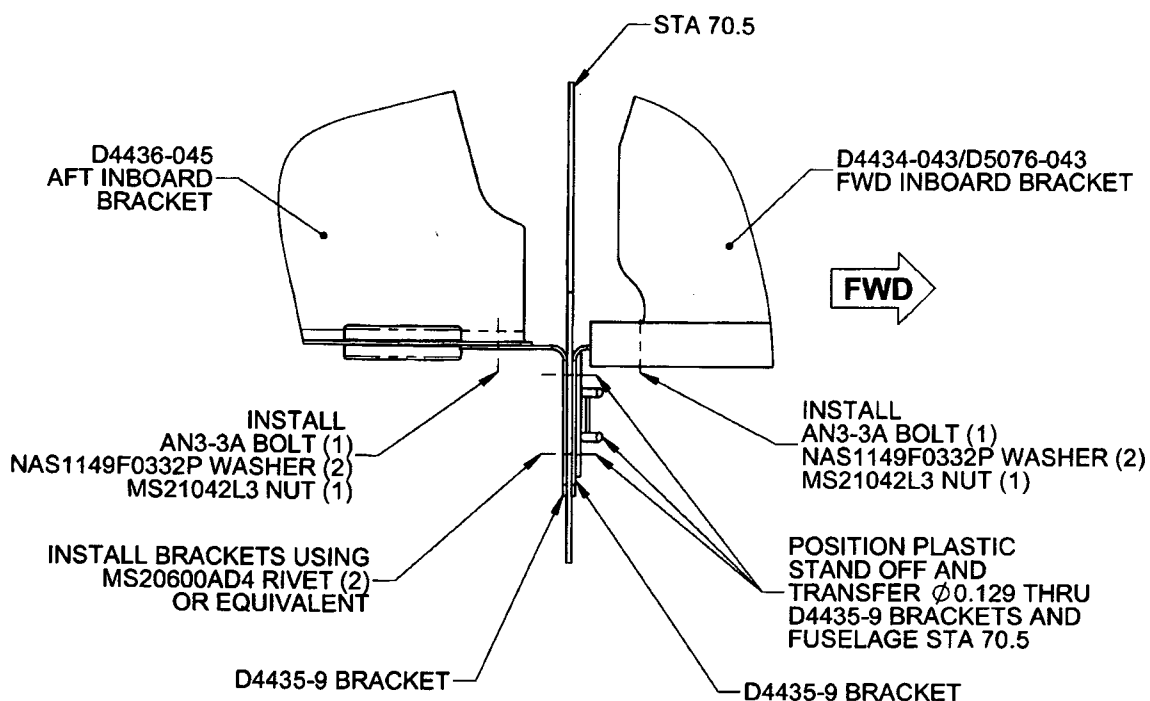
CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9590	SHEET 11 OF 19
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LOOKING UP AT STA 70.5

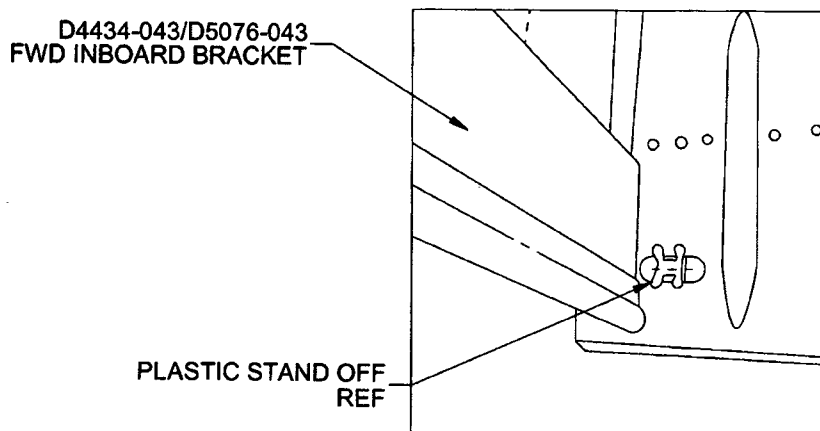


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)
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MFG. APPR.	N/A	DSI 9590	SHEET 12 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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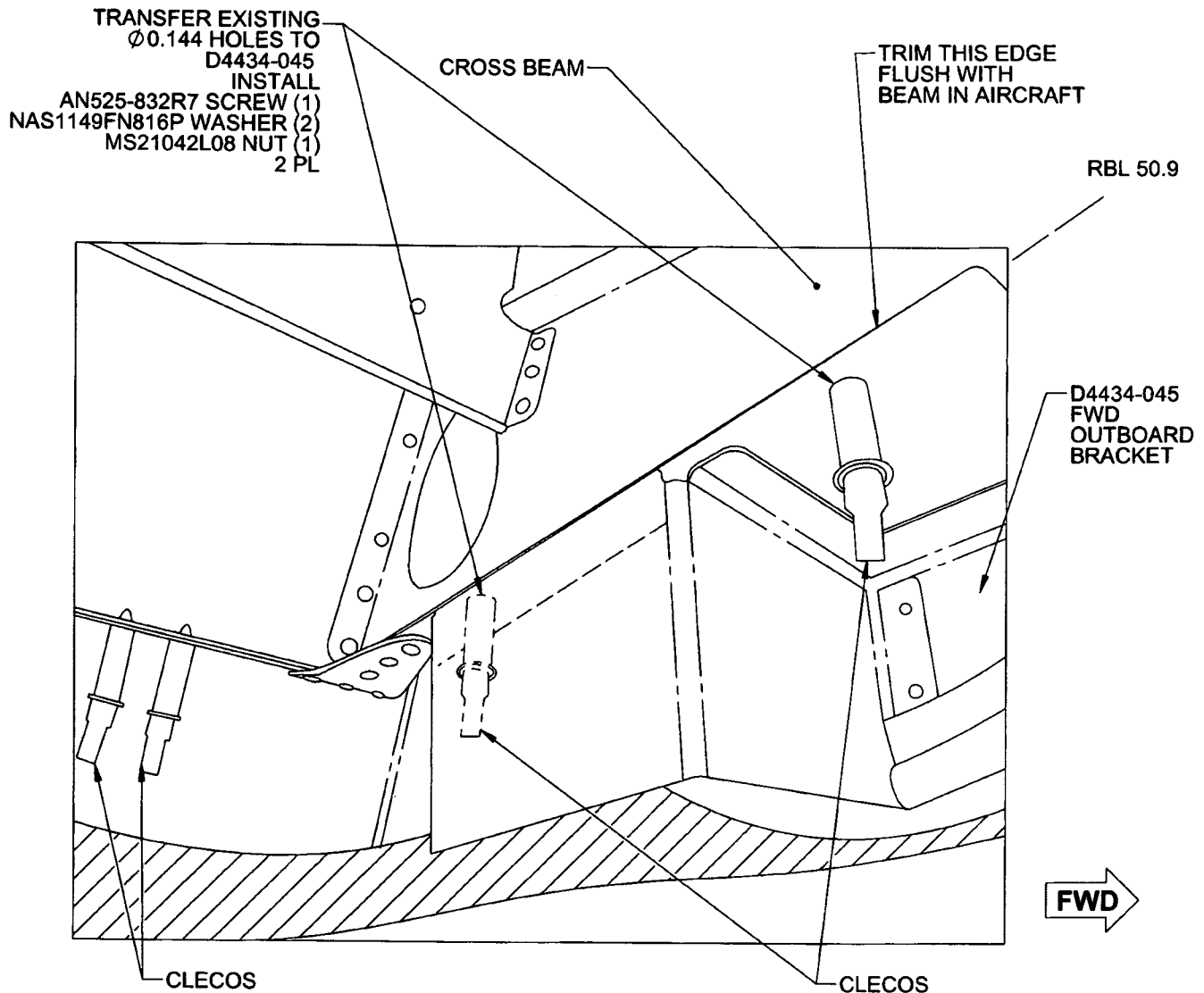


Figure 11. D4434-045 Bracket Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

DATE: 15.01.12
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 13 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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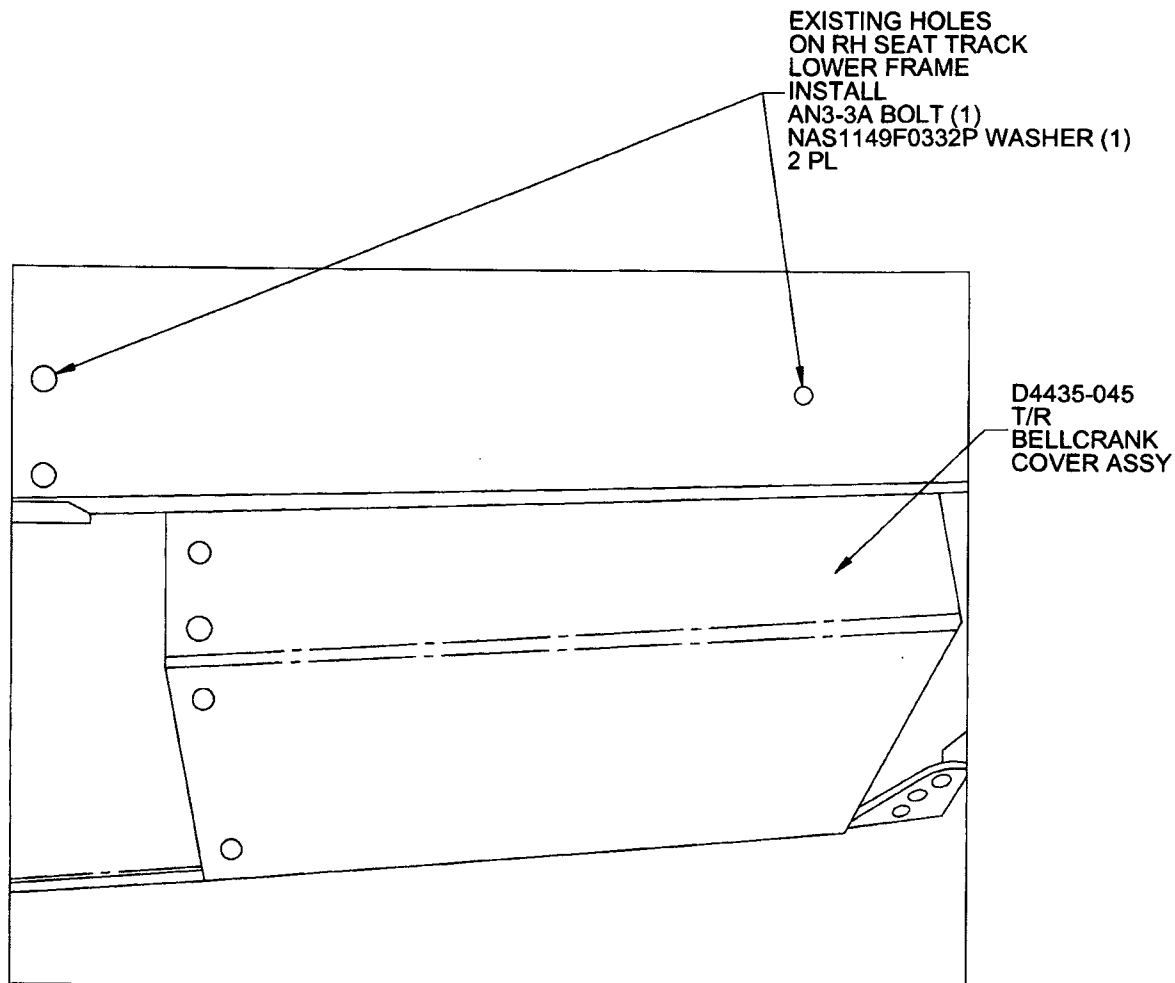


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
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MFG. APPR.	N/A	DSI 9590	SHEET 14 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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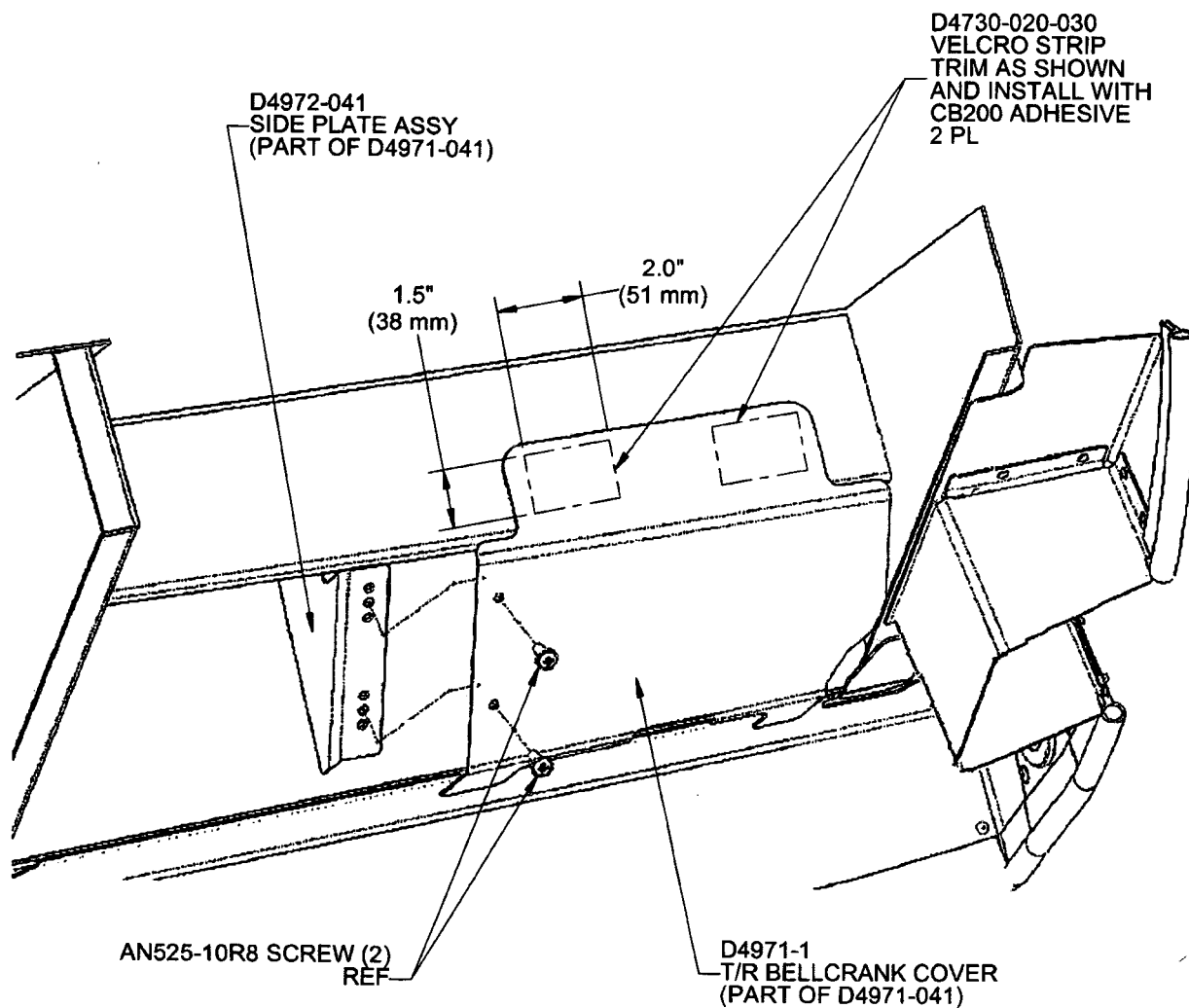


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

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D. SHEPHERD (DE # 02)

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 15 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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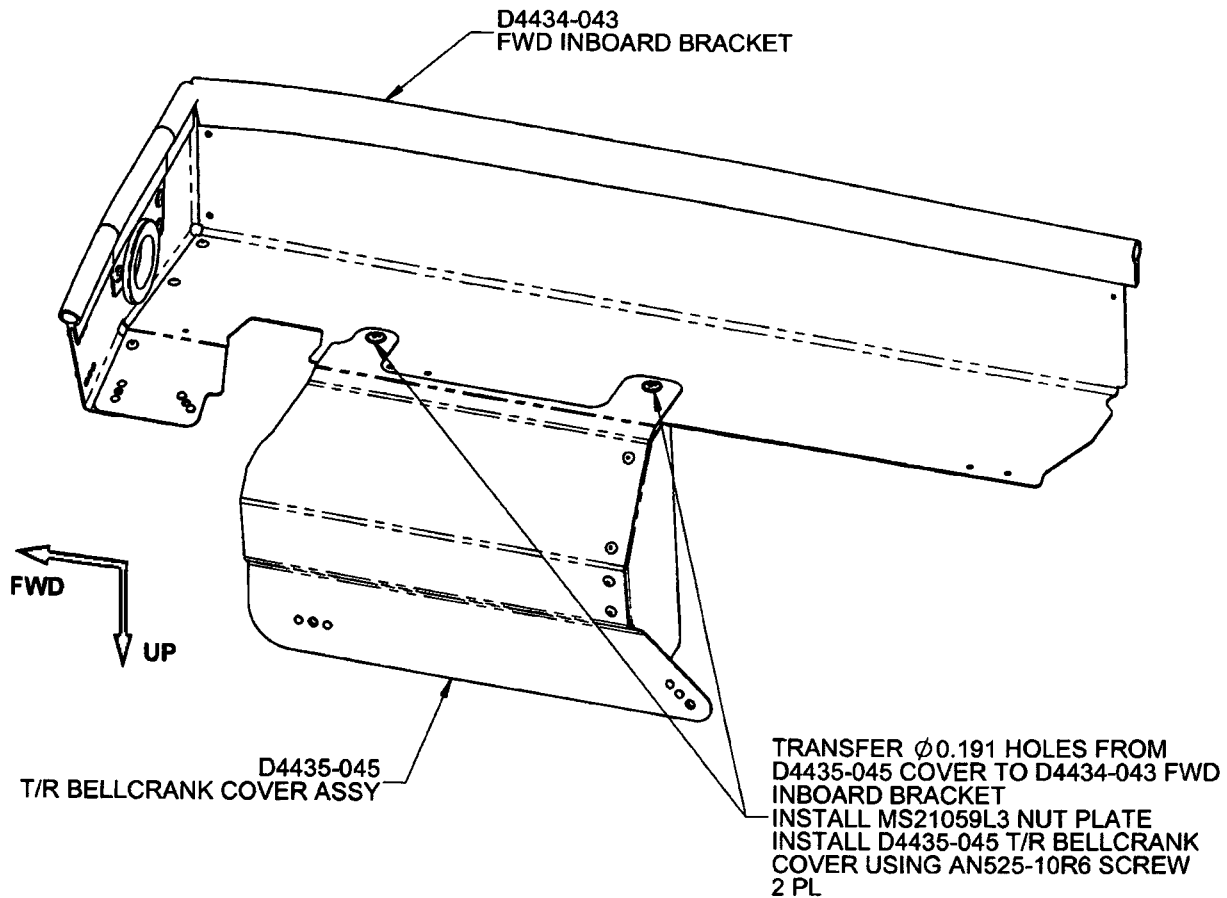


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

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DAO # 01-O-01

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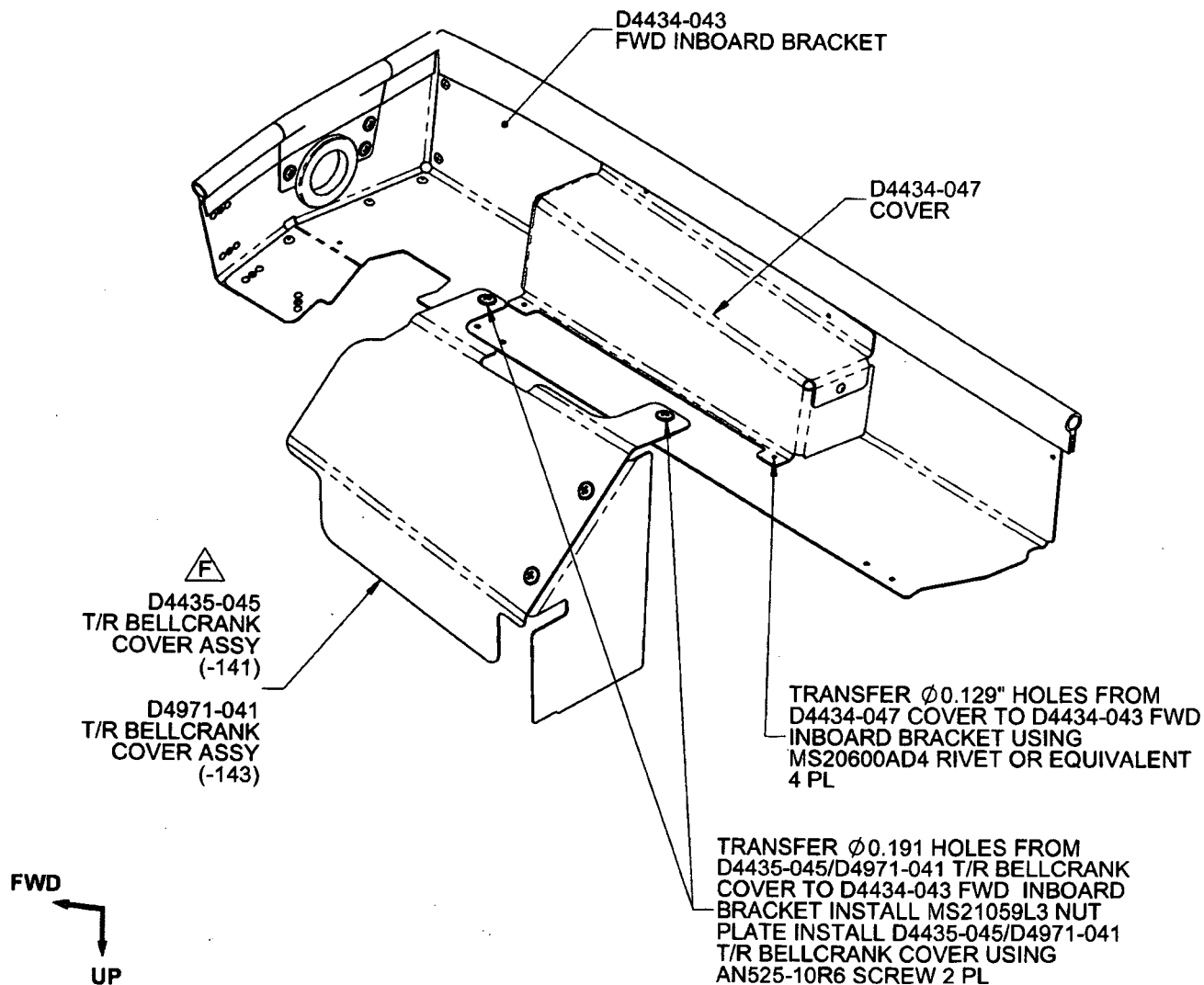


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation △
(D4434-047 is Optional on -141)

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 17 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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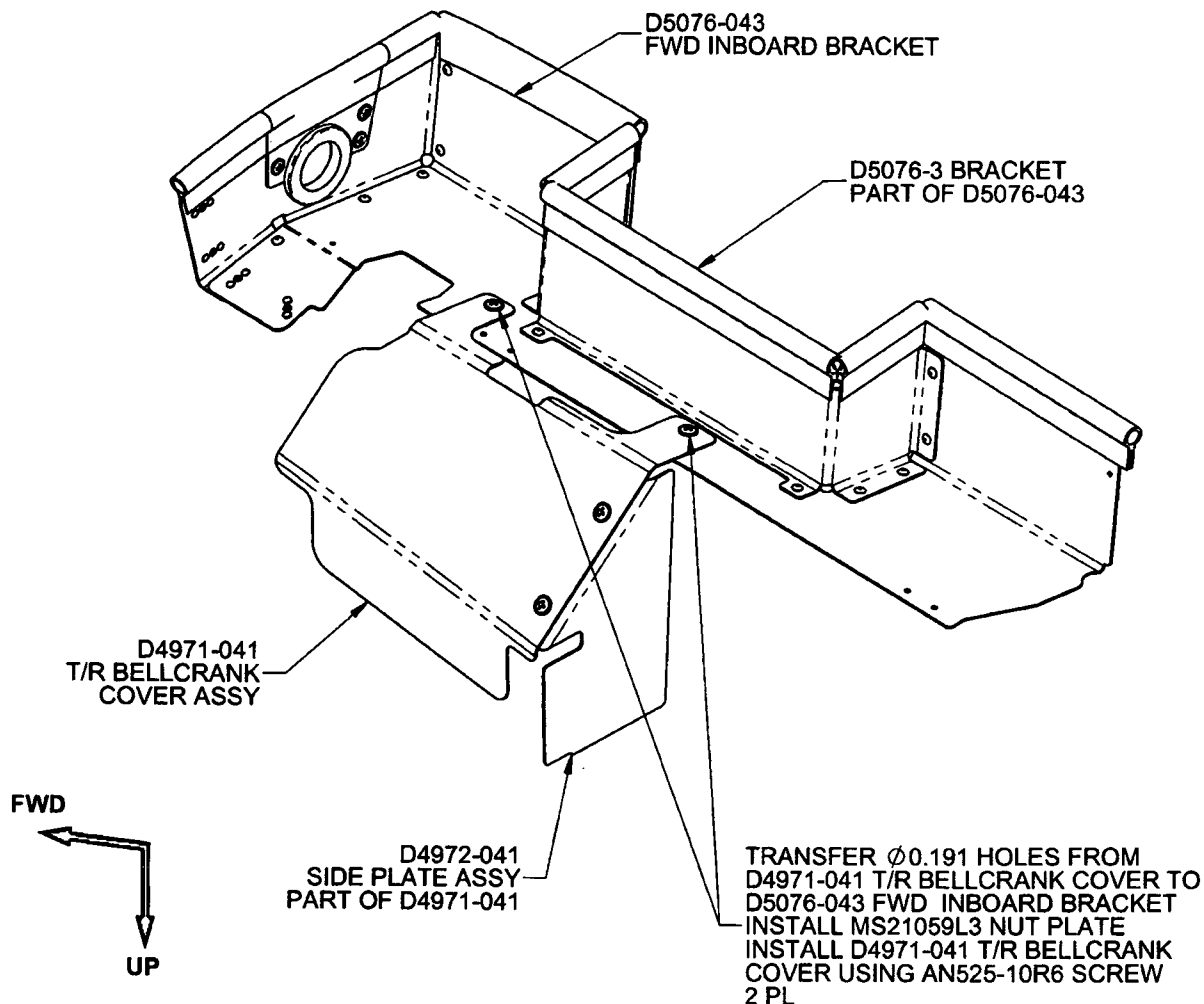


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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BRANCH
DAO # 01-O-01

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MFG. APPR.	N/A	SHEET 18 OF 19	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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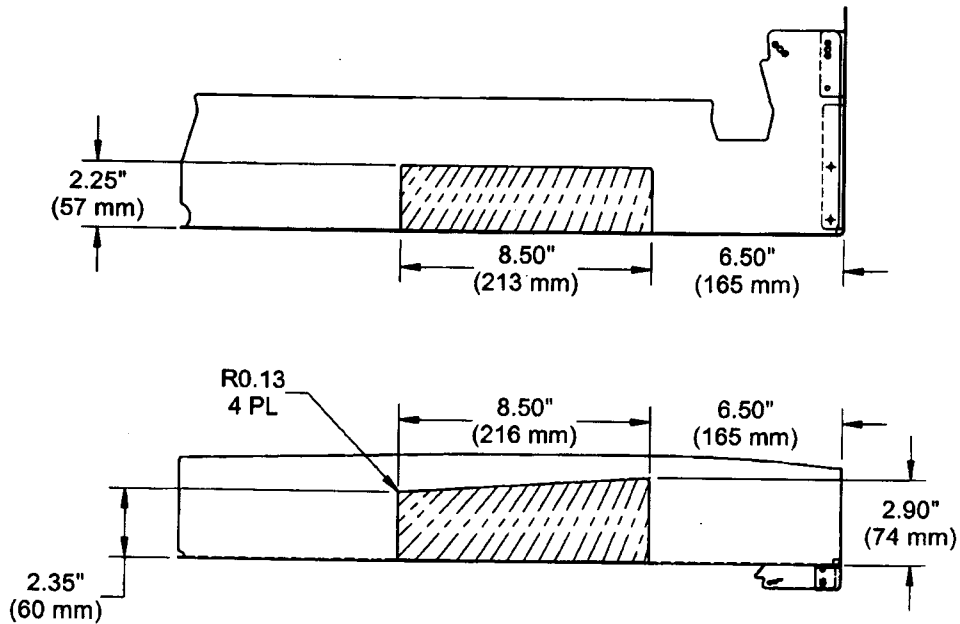
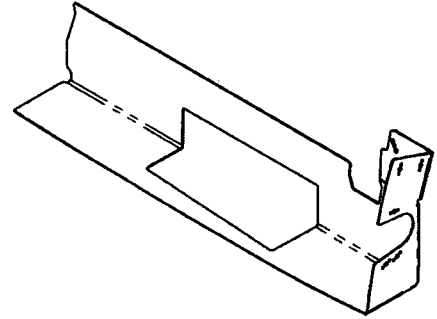


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9590	SHEET 19 OF 19
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2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L) 601-1607
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	[Signature]	TITLE	SCALE
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